

Thursday, January 12, 2017 3:40:56 PM

Page 1

DAS

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

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OTHER : _____									

Work Order ID 155364

Thursday, January 12, 2017 3:40:56 PM

155364

Page 3

Item ID: D2893-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 1/18/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/25/2017 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.08

Quality Control

DAS
21
9-89

JAN 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, January 12, 2017 3:40:56 PM

Page 1

Work Order ID: 155364

155364

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 1/18/2017

Required Date: 1/25/2017

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	3.0000	0.5	3		68-6 88 S&D	
DSK078									**			17/01/22	
D2893-1 Turning Detail													

Location

Loc Qty

Loc Code

MAT060

3

151098

1

153126

2

1

2

DQA: _____ Date: _____



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OTHER : _____					

DART AEROSPACE LTD		Work Order: 155364
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2,990	2,988	2,990	2,990	2,989
AB	0.440	0.460		0,460	0,460	0,460	0,460	0,460
AC	0.125	0.160		0,160	0,160	0,160	0,160	0,160
AD	0.040	0.060		0,050	0,050	0,050	0,050	0,050
AE	0.188	0.193		0,190	0,190	0,190	0,190	0,190
AF	0.125	0.160		0,138	0,138	0,138	0,138	0,138
AG	0.140	0.160		0,145	0,153	0,150	0,151	0,151
AH	1.360	1.400		1,378	1,380	1,378	1,380	1,380
AI	0.040	0.060		0,051	0,051	0,051	0,047	0,049
AJ	1.190	1.230		1,222	1,224	1,224	1,220	1,223
AK	0.010	0.020		0,010	0,010	0,010	0,010	0,010
AL	0.053	0.073		0,063	0,063	0,063	0,063	0,063
AM	0.240	0.260		0,250	0,250	0,250	0,250	0,250
AN	2.518	2.538		2,528	2,528	2,528	2,528	2,528
AO	84.39	90.39		87,39	87,39	87,39	87,39	87,39
AP	0.261	0.266		0,261	0,261	0,261	0,261	0,261
AQ	0.053	0.073		0,063	0,063	0,063	0,063	0,063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

Measured by: DAS 33	Date: 17/01/22
Audited by: 9-89 BA DAS 08	Date: 17-01-24
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

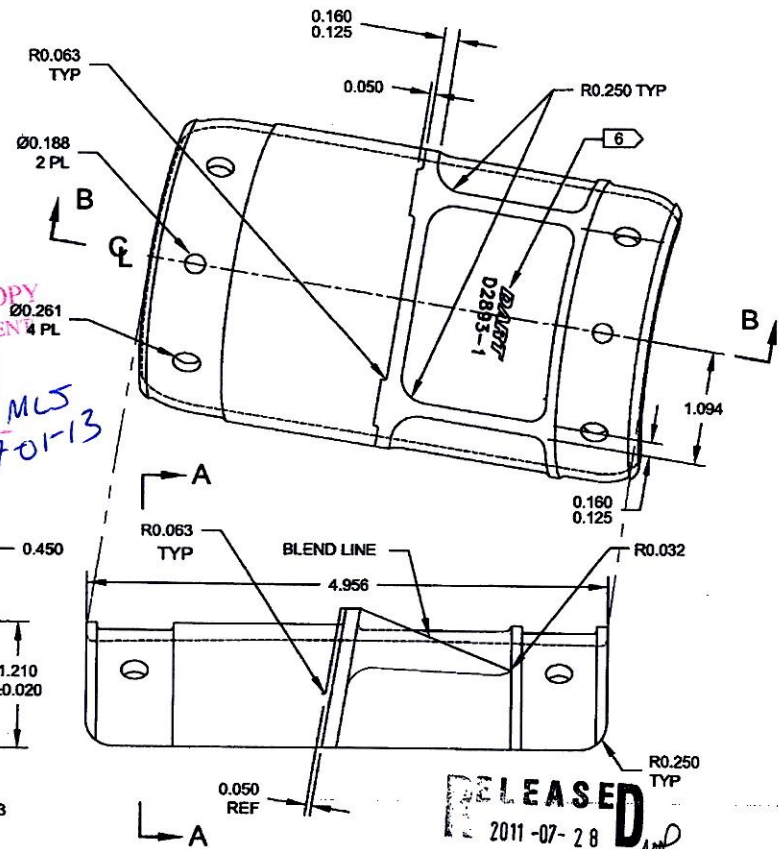
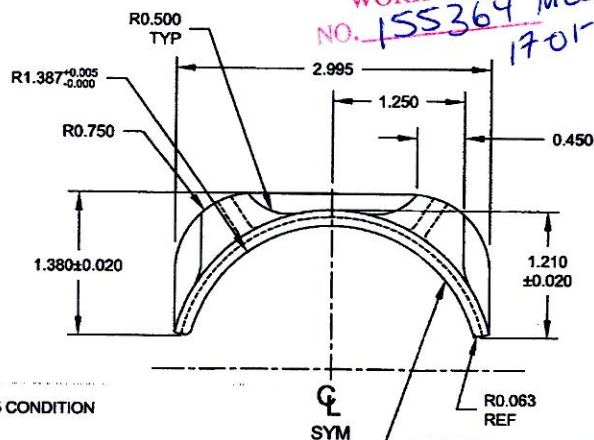
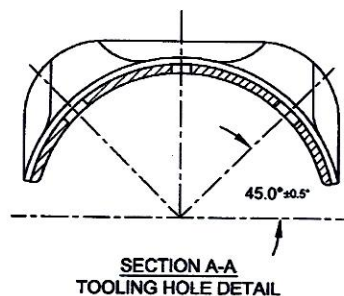
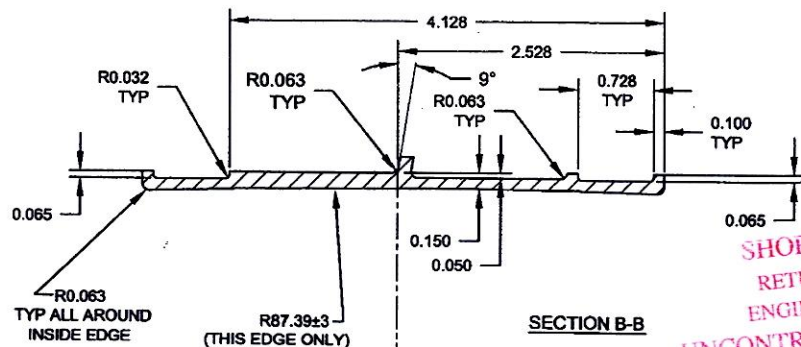
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AF	0.125	0.160		0.138				
AG	0.140	0.160		0.152				
AH	1.360	1.400		1.380				
AI	0.040	0.060		0.051				
AJ	1.190	1.230		1.225				
AK	0.010	0.020		0.010				
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AM	0.240	0.260		0.250				
AN	2.518	2.538		2.528				
AO	84.39	90.39		87.39				
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AQ	0.053	0.073		0.063				
AR								
AS								
AT								
Accept/Reject				✓				

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155364 MLS
1701-13

RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF XXXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2893-1 SUPPORT

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN	P		
DRAWN	P		
CHECKED	ASS		
MFG. APPR.			
APPROVED	AN		
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2893	REV. C SHEET 1 OF 1
TITLE D2.750 SUPPORT	SCALE NTS
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